

HAT

Work Order ID 65601 (1)



Page 1

January 20, 2011 10:55:43 AM

Item ID:	D4059-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Ski Assembly, Aft RH					
Start Date:	1/20/11	Start Qty:	1.00	Cust Item ID:		
Required Date:	1/27/11	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	CL	Date:	1/10/20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4059	A								

100		0.00							
	HandThermo								
Hand Finishing Thermoforming	Memo Pick Kit	0.00							
110		0.00							
	HandThermo								
Hand Finishing Thermoforming	Memo 1- Assemble as per Dwg D4059-042 2- install wearplates 3- Use wearbar to locate & transfer drill mounting holes as per dwg. 4- Install werbars as per dwg.	0.00							

Cancelled

U

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65601

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Page 2

Item ID: D4059-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Assembly, Aft RH

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6 Inspect dimensions to drawingQC5

Memo

0.00

0.00

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MF
11-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January 20, 2011 10:55:43 AM

Work Order ID: 65601

Parent Item: D4059-042

Parent Item Name: Ski Assembly, Aft RH

Start Date: 1/20/11

Required Date: 1/27/11

Start Qty: 1.00

Required Qty: 1.00

Comments: New Issue 10/03/16 Rev. A DL verified by:DD
10/04/05 DL Added Wearbars & assoc. hardware

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C5A		Purchased	No			100	Each	1,028.000	12	12			
--------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Bolt

Location

Loc Qty

Loc Code

ST350

1028

114330

11

115015

13

115371

100

~~115422~~

100

115594

6

115835

198

116419

500

116549

100

Returned to Stock
dt. 11/02/08.

OK
11/02/08

AN4C6A

Purchased

No

100

Each

331.0000

10

10



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

113121

327

115016

1

116003

76

~~116003~~

200

116400

50

Returned to Stock
dt. 11/02/08

OK
11/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 65601

Parent Item: D4059-042

Parent Item Name: Ski Assembly, Aft RH

Start Date: 1/20/11

Required Date: 1/27/11

Start Qty: 1.00

Required Qty: 1.00

D4015-041	Manufactured	No	100	Each	44.0000	12	12		
Wearbar Weldment									
<p><i>Returned to Stock</i> <i>Ok. 11/02/08</i> <i>63690</i></p>									
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
	ST114		44						
			44						
D4059-2	Manufactured	No	100	Each	0.0000	1	1		
Ski Section, Aft RH									
D4067-041	Manufactured	No	100	Each	7.0000	2	2		
Joggled Wearplate									
<p><i>Returned to Stock</i> <i>Ok. 11/02/08</i> <i>56342</i></p>									
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
	therm		7						
			7						
D4068-041	Manufactured	No	100	Each	0.0000	1	1		
Curved Wearplate									
MS21043-3	Purchased	No	100	Each	1,677.000	12	12		
Nut									
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
	FG		76						
	103691		76						
	ST301		1601						
	112314		1601						

January 20, 2011 10:55:43 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 20, 2011 10:55:43 AM

Work Order ID: 65601

Parent Item: D4059-042

Parent Item Name: Ski Assembly, Aft RH

Start Date: 1/20/11

Required Date: 1/27/11

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 Purchased No

100 Each 1,194.000 10 10



Nut



DL
11/02/07

Returned to Stock
DL 11/02/07

Location

Loc Qty

Loc Code

ST301

1194

114523

5

114784

2

115936

291

116188

596

116549

300

NAS1149C0432R Purchased No

100 Each 204.0000 10 10



Washer



DL
11/02/07

Returned to Stock
DL 11/02/07

Location

Loc Qty

Loc Code

ST297

204

114292

50

114742

63

116304

91

1116805

10

NAS1149C0463R Purchased No

100 Each 166.0000 10 10



Washer



Location

Loc Qty

Loc Code

ST297

166

112314

8

115358

158

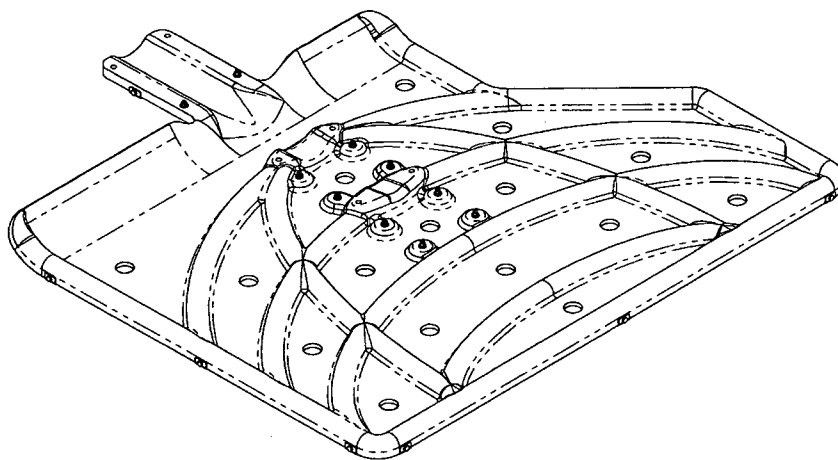
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

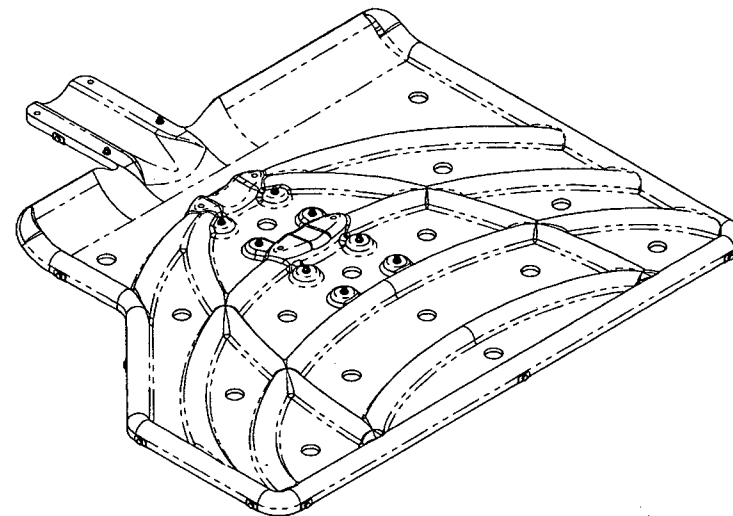
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4059-041 AFT SKI ASSY, LH



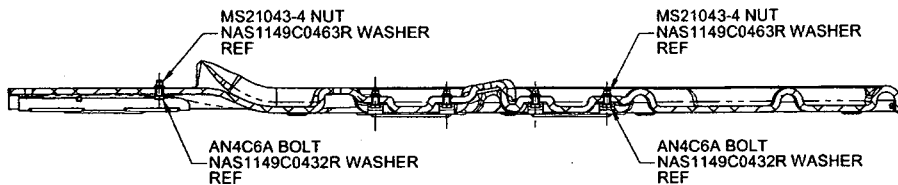
D4059-042 AFT SKI ASSY, RH

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65401
C211101/20

RELEASED
2010-04-07
wp

A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.31		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4059	REV. A
TITLE AFT SKI ASSY	SCALE NTS
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4059-041	AFT SKI ASSY, LH
2	12	D4015-041	WEARBAR
3	1	D4059-1	AFT SKI SECTION
4	2	D4067-041	412 JOGGLED WEARPLATE
5	1	D4068-041	412 CURVED WEARPLATE
6	12	AN3C5A	BOLT
7	10	AN4C6A	BOLT
8	12	MS21043-3	NUT
9	10	MS21043-4	NUT
10	10	NAS1149C0432R	WASHER
11	10	NAS1149C0463R	WASHER

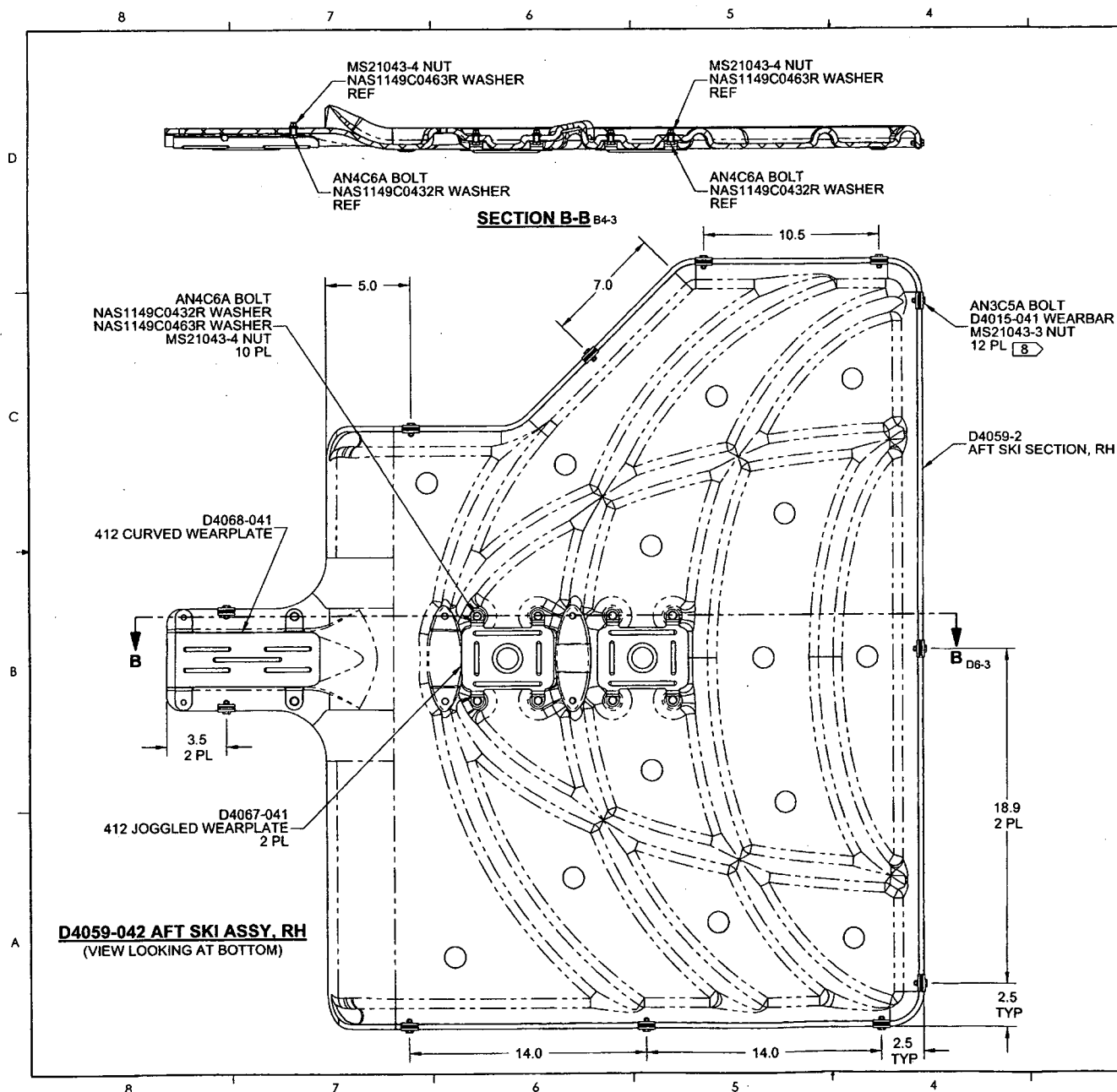
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WITHOUT NOTICE
WORK ORDER
NO. 65001

RELEASED
2010-04-07
MD

- D4059-041 NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 26.0 lbs
 8) LOCATE D4015-041 (ITEM 2) AS SHOWN.
 TRANSFER DRILL Ø0.191" HOLE FROM D4015-041 TO D4059-1.
 CHAMFER HOLE 0.03 X 45°.
 FASTEN USING PRESCRIBED HARDWARE
 9) TORQUE: AN3 NUTS = 15-20 in-lb
 AN4 NUTS = 50-70 in-lb

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MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		AFT SKI ASSY	NTS
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D4059-041 AFT SKI ASSY, LH
(VIEW LOOKING AT BOTTOM)



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4059-042	AFT SKI ASSY, RH
2	12	D4015-041	WEARBAR
3	1	D4059-2	AFT SKI SECTION, RH
4	2	D4067-041	412 JOGGLED WEARPLATE
5	1	D4068-041	412 CURVED WEARPLATE
6	12	AN3C5A	BOLT
7	12	MS21043-3	NUT
8	10	MS21043-4	NUT
9	10	AN4C6A	BOLT
10	10	NAS1149C0432R	WASHER
11	10	NAS1149C0463R	WASHER

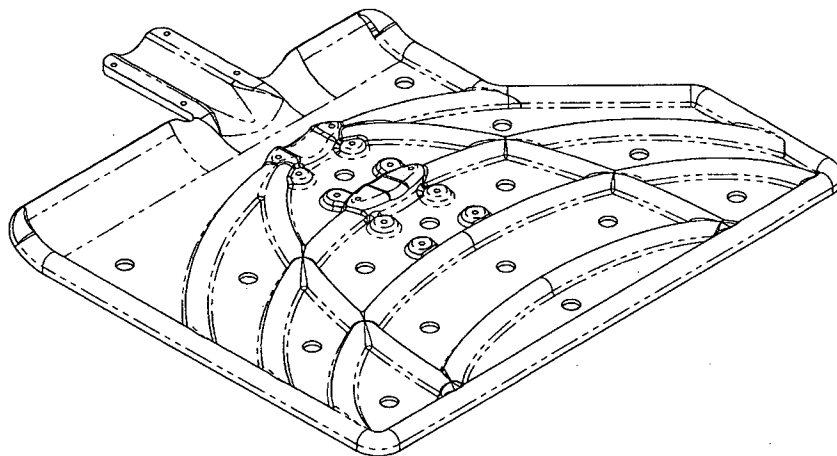
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WORK ORDER
NO. 65601

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WMP

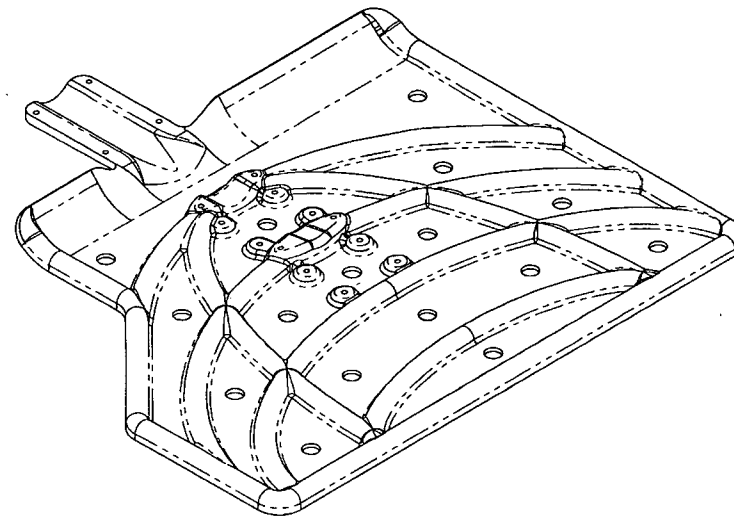
D4059-042 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 26.0 lbs
- 8) LOCATE D4015-041 (ITEM 2) AS SHOWN.
TRANSFER DRILL $\varnothing 0.191$ " HOLE FROM D4015-041 TO D4059-2.
CHAMFER HOLE 0.03 X 45°.
FASTEN USING PRESCRIBED HARDWARE
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D4059 REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE AFT SKI ASSY SCALE NTS
DE APPR.	<i>[Signature]</i>	
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D4059-1 AFT SKI SECTION, LH



D4059-2 AFT SKI SECTION, RH

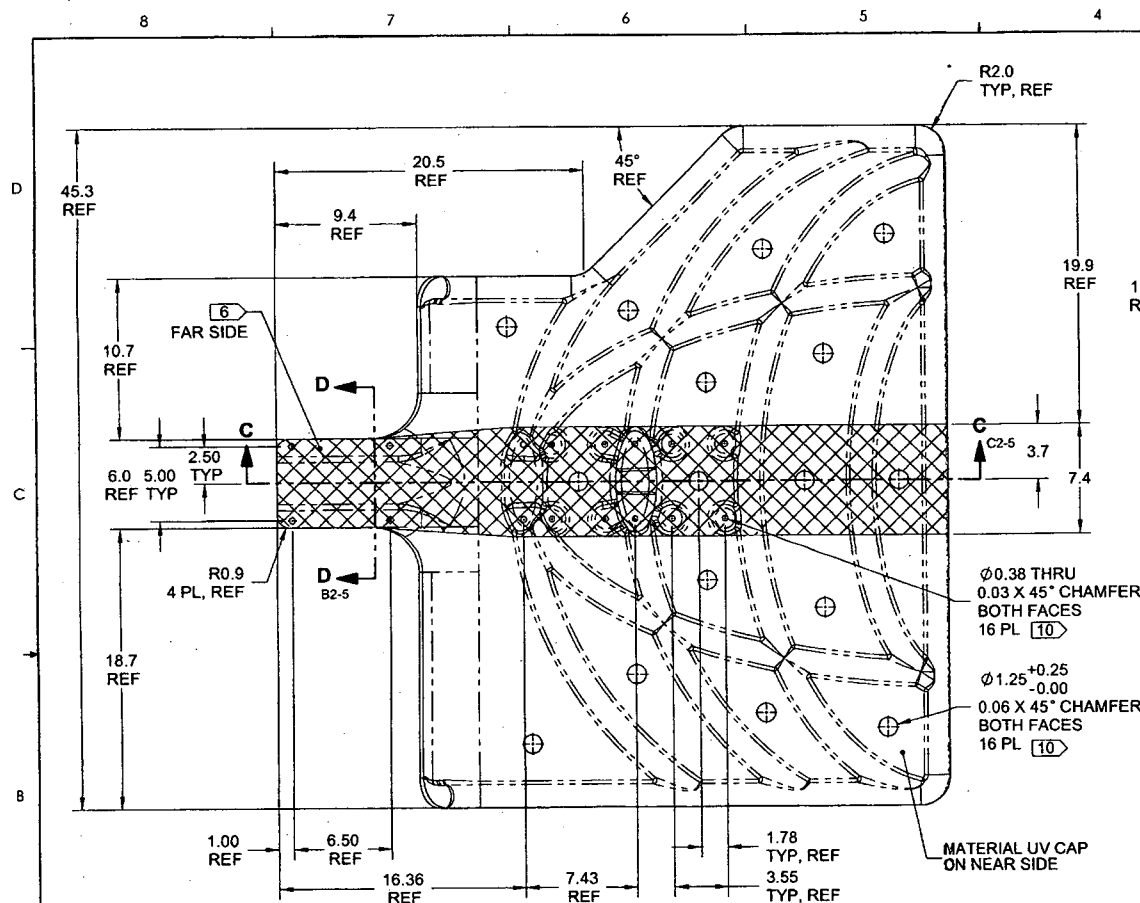
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WORK ORDER
NO. 65601

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2010-04-07
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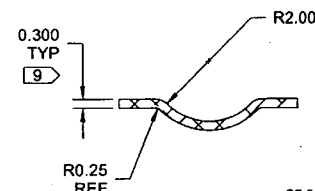
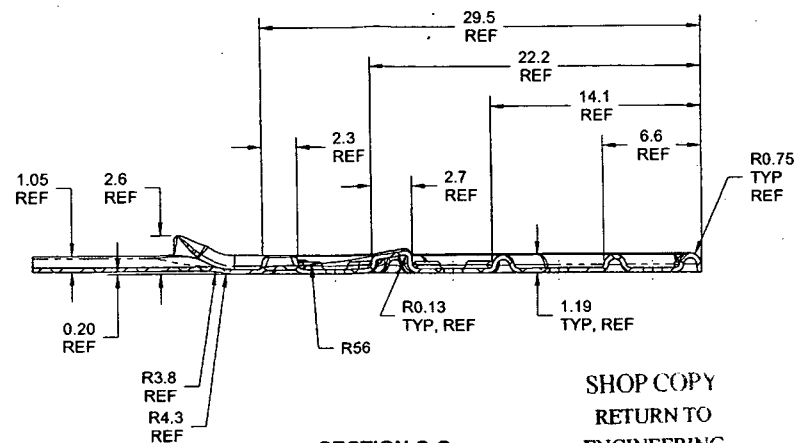
D4059-1/-2 NOTES:

- 1) MATERIAL: ALEXTRA ET SHEET, 0.300 THICK
REF. DART SPEC. M-ALXTRAB.300
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4059-X" AND B/N USING VIBRATING SYLUS
- 7) WEIGHT: 23.50 lbs EACH
- 8) THERMOFORMING: PER DT9601 (D4059-1) OR DT9602 (D4059-2) AND DART QSI 022
- 9) MINIMUM THICKNESS: IN SHADED AREA = 0.210
OUTSIDE SHADED AREA = 0.175
- 10) PICK UP ON EXISTING MOLD MARKINGS AND DRILL THRU AS SHOWN

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4059	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		AFT SKI ASSY	NTS
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D4059-1 AFT SKI SECTION
(VIEW LOOKING AT TOP SIDE OF SKI)
THERMOFORM PER DT9601 AND QSI 022

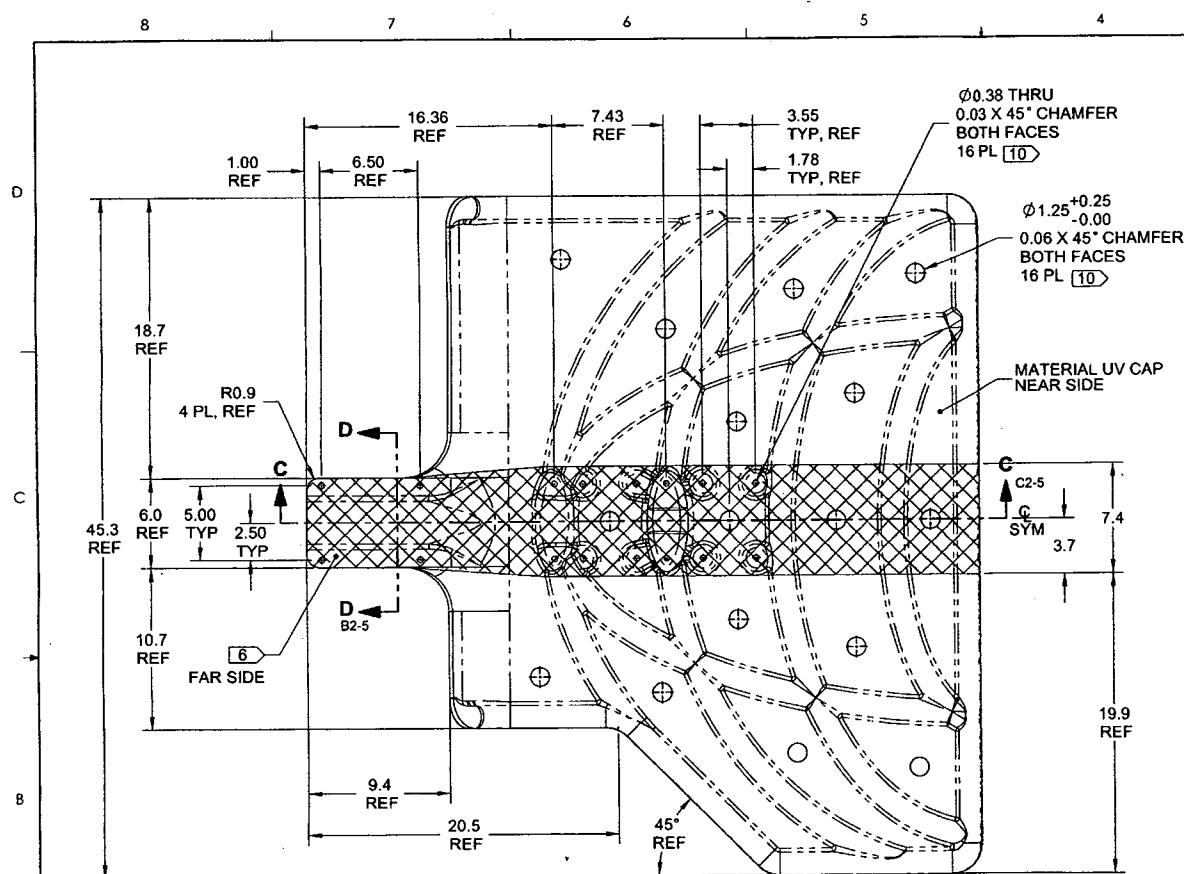


SECTION D-D
VIEW ROTATED 90° CW
SCALE 2X

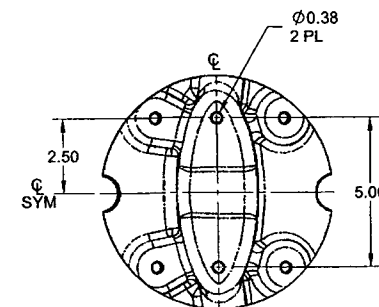
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2010-04-07
AW

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DE APPR.			NTS
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D4059-2 AFT SKI SECTION
(VIEW LOOKING AT TOP SIDE OF SKI)
THERMOFORM PER DT9602 AND QSI 022



VIEW E-E
SCALE 2X
A6-5
A6-6
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NO. 65601

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2010-04-07
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CHECKED		DRAWING NO. D4059	REV. A
MFG. APPR.		TITLE	SHEET 6 OF 6
APPROVED		AFT SKI ASSY	SCALE
DE APPR.			NTS
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